

Work Order ID 51800

Thursday, September 03, 2009 11:41:25 AM



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

RL ml

Date:

09-03

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750	Rev F								

100

0.00



DC

Document Control

DOCUMENT CONTROL

Memo

0.00

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

807/10/13

HJ-fa BG 09/10/13

B 51800

Work-Order ID 51800

Thursday, September 03, 2009 11:41:25 AM

Page 2

Item ID: D350-636-011

Accept

Revision ID: F

Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

Skidtubes

Skidtubes

Memo

0.00

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 & DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R ☐ ☐ Aluminum Rod

10-Grind welds flush as per Dwg D2750

BE 09/09/15

AUM 9-9-16

mill 11682 BE 09/09/15

-AUM 9-9-15

Work Order ID 51800

Thursday, September 03, 2009 11:41:25 AM

Page 3

Item ID: D350-636-011

Accept

Setup Start

Revision ID: F

Stop

Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

12- Scribe batch# inside per dwg D2750

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

2) 8/21/09/15

(10) /

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) 8/21/09/15

(10) /

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

ml 09 09 10 (10)

Work Order ID 51800

Thursday, September 03, 2009 11:41:25 AM

Page 4

Item ID: D350-636-011

Accept

Setup Start

Revision ID: F

Stop

Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Q.M. 09-09-160

Work Order ID 51800

Thursday, September 03, 2009 11:41:25 AM

Page 5

Item ID: D350-636-011

Accept

Revision ID: F

Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)
as per dwg D2750.2-Open up holes of Detail B to 0.750" (total of 4 holes per side)
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291batch: 4112391 ☐☐☐

exp. date: 02/20/2010

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004
(welding instructions on sheet 8)A/R ☐☐☐ Aluminum Rod batch: 4111999

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per
dwg D2750

9-9-25

AD 09.10.01

ANM 9-10-05

Work Order ID 51800

Thursday, September 03, 2009 11:41:25 AM

Page 6

Item ID: D350-636-011

Accept

Revision ID: F

Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

11-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

Quality Control

0.00

2) 807/10/06

(X)

f

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

Quality Control

0.00

2) 807/10/06

(X)

f

190

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

Hand Finishing

0.00

2) 807/10/07

(X)

Ø

WorkOrder ID 51800

Thursday, September 03, 2009 11:41:25 AM

Page 7

Item ID: D350-636-011

Revision ID: F

Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:




Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M 112269 Memo START TIME: 11:25 OVEN TEMPERATURE: 325 FINISH TIME: 11:55	0.00 0.00	BL 09-10-7			①			
210  QC Quality Control	QC3- Inspect Part Finish Memo Inspect for foreign object per QSI 024	0.00 0.00	41 09/10/08			ⓧ	⊘		
220  HandFinish Hand Finishing	HandFinishing Memo 1- Install inserts as per Dwg D2750	0.00 0.00	41 09/10/08			ⓧ	⊘		

Work Order ID 51800

Thursday, September 03, 2009 11:41:25 AM

Page 8

Item ID: D350-636-011

Accept

Revision ID: F

Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230



HandFinish

Hand Finishing

HandFinishing

Memo

✓ 1-Inspect for Foreign Objects

✗ 2-Spray inside of tube with "LPS-3" batch: N/A

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750
SIKA FLEX 241

✓ BATCH: 1112391

EXP DATE: 10/20

✓ 4-assemble o-ring to plug as per dwg D3492 and apply o-ring lube
A/R 55-o-ring lube batch: M101223

✓ 5-Coat all exposed fasteners with "LPS Procyon" batch: 11104251

0.00

0.00

0.00

0.00

⇒ MH 09/10/08

2) S 09/10/08

(11)

(9)

Work Order ID 51800

Thursday, September 03, 2009 11:41:25 AM

Page 9

Item ID: D350-636-011

Accept

Revision ID: F

Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

250

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

9/10/8 1050

260

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*****ensure antiseize is on AN8C21A bolts*****

258 02/10/13

70 1

270

Packaging

0.00



Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-011

REV-G

129/10/14 1

Work Order ID 51800

Page 10

Thursday, September 03, 2009 11:41:25 AM

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/20 *[Signature]*
MF
09-10-19

Picklist Print

Thursday, September 03, 2009 11:41:31 AM

Page 1

Work Order ID: 51800

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2744RevC		Manufactured	No			110	Each	50.0000	1.0000			
												
Cap												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	50
44892	15
47488	35

D2600-3-BENTRevD1 Manufactured No



Extrusion Bent

D2743RevB Manufactured No



Crossbolt Spacer

110 Each 0.0000 1.0000

160 Each 294.0000 8.0000

Warehouse Loc Qty Loc Code
Location

Main Warehouse

LG	50
50281	50

Main Warehouse

ST	244
44891	2
45555	177
48275	65

Handwritten notes:
BE 09/09/15
B 50675 (1) BE 09/09/15

Handwritten notes:
8 PD 09/10/01

Picklist Print

Thursday, September 03, 2009 11:41:31 AM

Work Order ID: 51800

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH



Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739RevD 		Manufactured	No			160	Each	6.0000	1.0000 			
350 I Beam												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

LG

4

50353

4

Main Warehouse

ST

2

47124

1

47681

1

D3490-3RevA

Manufactured No

160

Each

112.0000

4.0000




Cross Bolt Spacer

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

112

45560

22

47471

35

48276

55

B 51930 → 4
PD 09.10.01

Picklist Print

Thursday, September 03, 2009 11:41:31 AM

Work Order ID: 51800

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-1RevA		Manufactured	No			160	Each	165.0000	4.0000			



Cross Bolt Spacer

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	165	
45338	2	
47118	4	
47657	50	
48277	109	

ALS4-1032-225

Purchased

No

220

Each

8,785.000

38.0000



Insert

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	8785	
107441	16	
110768	8769	

D3492-041RevC

Manufactured

No

230

Each

3.0000

8.0000



Plug Assembly

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	3	
43816	3	

4 PD 09.10.01

x 38 21 09/10/08

x 8 21 09/10/08

Picklist Print

Page 4

Thursday, September 03, 2009 11:41:31 AM

Work Order ID: 51800

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-3RevA		Manufactured	No			230	Each	22.0000	1.0000			



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

B50216

xl 09/10/08

Main Warehouse

ST

22

47720

11

50216

11

AN8C35A

Purchased

No

230

Each

167.0000

1.0000



BOLT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

167

102180

1

106896

1

110105

65

110847

100

xl 09/10/08

Picklist Print

Page 5

Thursday, September 03, 2009 11:41:31 AM

Work Order ID: 51800



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1RevA Wearshoe		Manufactured	No			230	Each	18.0000	1.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

40551

1

47537

4

50231

13

* 41 09/10/08

D3488-041RevB

Manufactured

No



230

Each

29.0000

1.0000



Blade Fitting Assembly, LH

* ?

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

41853

1

44530

8

47348

20

* 41 09/10/08

Thursday, September 03, 2009 11:41:31 AM

Shop Packet Print

Page 5

Picklist Print

Thursday, September 03, 2009 11:41:31 AM

Work Order ID: 51800



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH



Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-3RevA  Gasket		Manufactured	No			230	Each	27.0000	1.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	27	
46531	2	
47440	2	
47722	11	
50240	12	

AN6C44A

Purchased

No



BOLT

230 Each 172.0000 4.0000


<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
103964	2	
Main Warehouse		
ST	170	
110105	4	
110155	14	
110665	1	
110865	51	
111605	50	
111649	50	

X1 M 09/10/08

x4 M 09/10/08

Picklist Print

Thursday, September 03, 2009 11:41:31 AM

Work Order ID: 51800

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH



Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8 		Purchased	No			230	Each	92.0000	1.0000 			
NUT												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	92
110584	5
111424	2
11637	21
112243	44
112492	20

x1 JH 09/10/08

D3536-25RevA

Manufactured No



Gasket

*



Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	21
45569	1
47011	2
47526	8
60266	10

x1 JH 09/10/08

Picklist Print

Thursday, September 03, 2009 11:41:31 AM

Work Order ID: 51800



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH


Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3631-1RevA  Washer		Manufactured	No			230	Each	105.0000	8.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1351908

x8 M 09/10/09

38139

105

45353

6

47437

16

83

D3791-1RevA



Manufactured

No

230

Each

18.0000

1.0000

Wearplate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

47536

8

50269

10

(x1) M 09/10/09

Picklist Print

Page 9

Thursday, September 03, 2009 11:41:31 AM

Work Order ID: 51800



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH


Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			230	Each	2,450.000	38.0000			

Warehouse

Loc Qty

Loc Code

Location

OFFSHORE

FG

100

103585

100

Main Warehouse

FP

-44

112116

-44

Main Warehouse

ST

2394

112116

2394

M112612

x38 2/8 09/10/08

Picklist Print

Thursday, September 03, 2009 11:41:31 AM

Work Order ID: 51800



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB		Manufactured	No			230	Each	272.0000	8.0000			
Bushing												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 272

34817 2

36230 8

37303 1

39587 2

40726 2

41114 2

42778 19

43754 2

44893 37

45556 69

46695 18

48278 110

x 8 09/10/08

AN3C5A

Purchased

No

230

Each

646.0000

34.0000



Bolt

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 646

111424 8

111707 338

112314 200

112489 100

112720

x 34 09/10/08

Picklist Print

Thursday, September 03, 2009 11:41:31 AM

Work Order ID: 51800

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH



Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3537-1RevC  Wearpad		Manufactured	No			230	Each	46.0000	3.0000 			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse	1351918	
FP	46	
48288	3	
50321	43	

x3 41 09/10/08

AN960C816L

Purchased

No

230

Each

330.0000

1.0000




WASHER

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	330	
104093	2	
107520	4	
110139	29	
10372	36	
110584	100	
111424	159	

x1 41 09/10/08

D3492-043RevC

Manufactured

No

230

Each

0.0000

8.0000




Plug Assembly

13516412

x8 41 09/10/08

Picklist Print

Thursday, September 03, 2009 11:41:31 AM

Work Order ID: 51800

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3C6A 		Purchased	No			230	Each	1,048.000	4.0000			
BOLT												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1048

110372 72

111982 976

NAS1611-013

Purchased

No

230

Each

320.0000

1.0000



O-RING

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 320

106513 11

111424 109

111758 200

NAS1611-010

Purchased

No

230

Each

345.0000

1.0000



O-RING

* ?

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 345

110715 50

110915 295

02594-3 / B 51613

x8 48 09/10/08

PTO ~~last page~~ =>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/10/08	N/A	Replace "O" Ring NAS 1611-010 for D2594-3 "O" Rings	JH	09/10/08	18		S 09/10/08

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, September 03, 2009 11:41:31 AM

Work Order ID: 51800

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3535-25RevB Manufactured No



Wearshoe

Warehouse Loc Qty Loc Code

Location

Main Warehouse

B51663

x1 09/10/08

ST

11

47523

11

D3794-1RevA Manufactured No



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

B51668

x1 09/10/08

ST

7

46530

1

47212

2

47721

4

MS21043-6 Purchased No



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1132

110584

34

11424

98

112314

1000

x4 09/10/08

Thursday, September 03, 2009 11:41:31 AM

Shop Packet Print

Picklist Print

Thursday, September 03, 2009 11:41:31 AM

Work Order ID: 51800

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3493-1RevA Washer		Manufactured	No			260	Each	115.0000	2.0000			

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 115

44902 15

47710 100

47710 9/10/8 SP

MS21083C8

Purchased

No

260

Each

92.0000

2.0000

NUT

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 92

110584 5

111424 2

111637 21

112243 44

112492 20

112243 9/10/8 SP

Picklist Print

Page 15

Thursday, September 03, 2009 11:41:31 AM

Work Order ID: 51800

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH


Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C21A 		Purchased	No			260	Each	112.0000	2.0000			
BOLT												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	112	
105160	1	
107596	1	
107924	2	
109092	2	
110341	2	
110342	4	
111605	50	
111684	50	

111684 54

AN960C816L

Purchased

No

260

Each

330.0000

2.0000



WASHER

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

111424 54 9/10/8

Thursday, September 03, 2009 11:41:31 AM

Shop Packet Print

Page 15

Picklist Print

Page 16

Thursday, September 03, 2009 11:41:31 AM

Work Order ID: 51800



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H3L 		Purchased	No			260	Each	350.0000	4.0000 			
WASHER												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE	M	
FG	40	
102472	40	
Main Warehouse		
ST	310	
110450	2	
110806	8	
111819	300	

D2741RevC

Manufactured No

260 Each 40.0000 1.0000



Blade, 350 Skidtube



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	40	
20770	0	
45320	1	
47113	39	

Xu M 09/10/00
47113 9/10/8 SP

Thursday, September 03, 2009 11:41:31 AM

Shop Packet Print

Page 16

Picklist Print

Page 17

Thursday, September 03, 2009 11:41:31 AM

Work Order ID: 51800



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3532-1RevA

Manufactured

No

260

Each

43.0000

2.0000



Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43

38161

2

44904

41

44904 SP

NAS1515H8L

Purchased

No

260

Each

129.0000

2.0000



WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

129

107581

34

108964

1

111650

94

111650 9/10/8 SP

Thursday, September 03, 2009 11:41:31 AM

Shop Packet Print

Page 17

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

51800

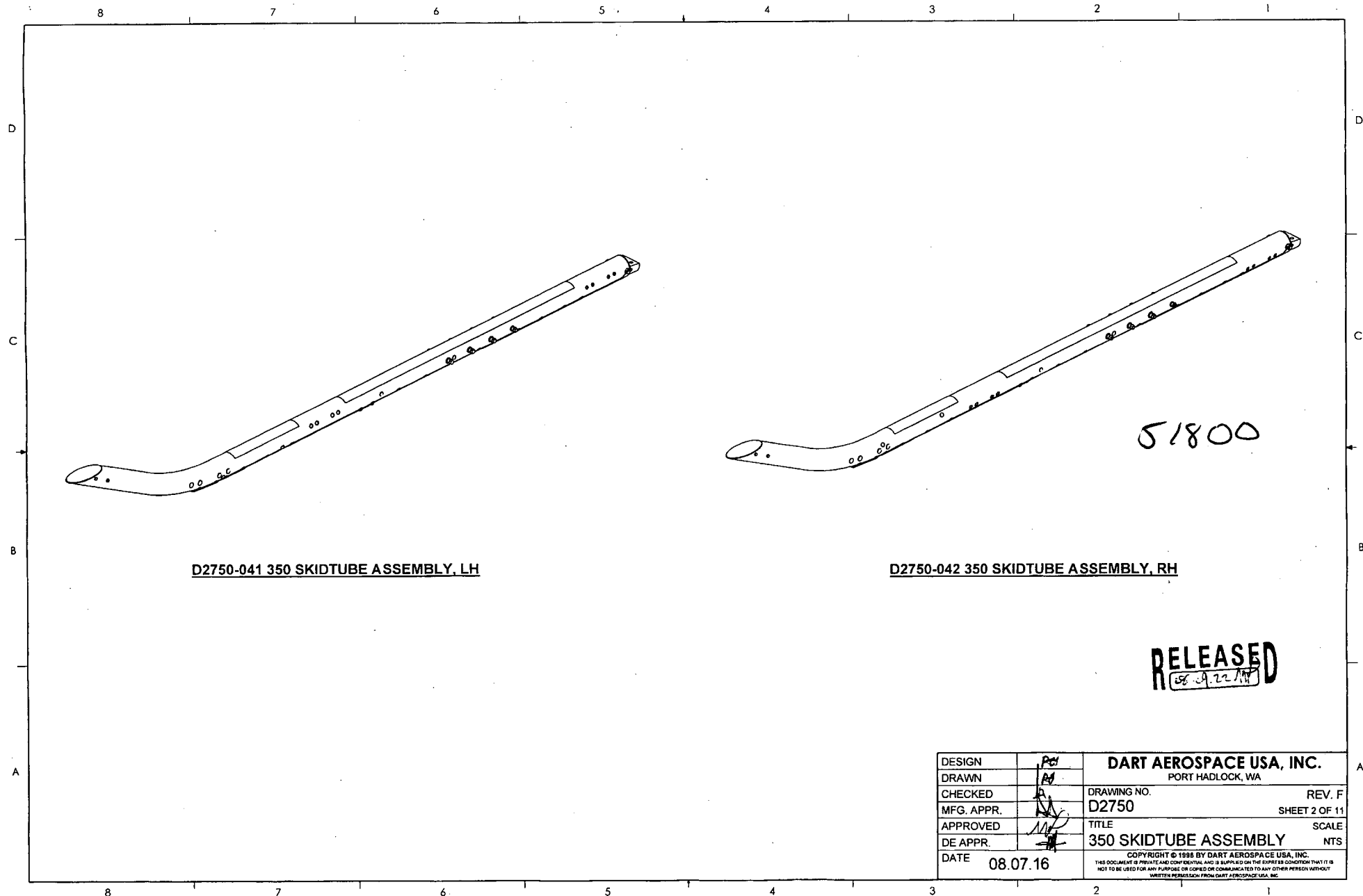
RELEASED

F	INCORPORATE DSI 9413: QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO. D2750
REV. F
SHEET 1 OF 11
TITLE 350 SKIDTUBE ASSEMBLY
SCALE NTS

COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED UNDER THE EXPRESS CONDITION THAT IT IS
NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

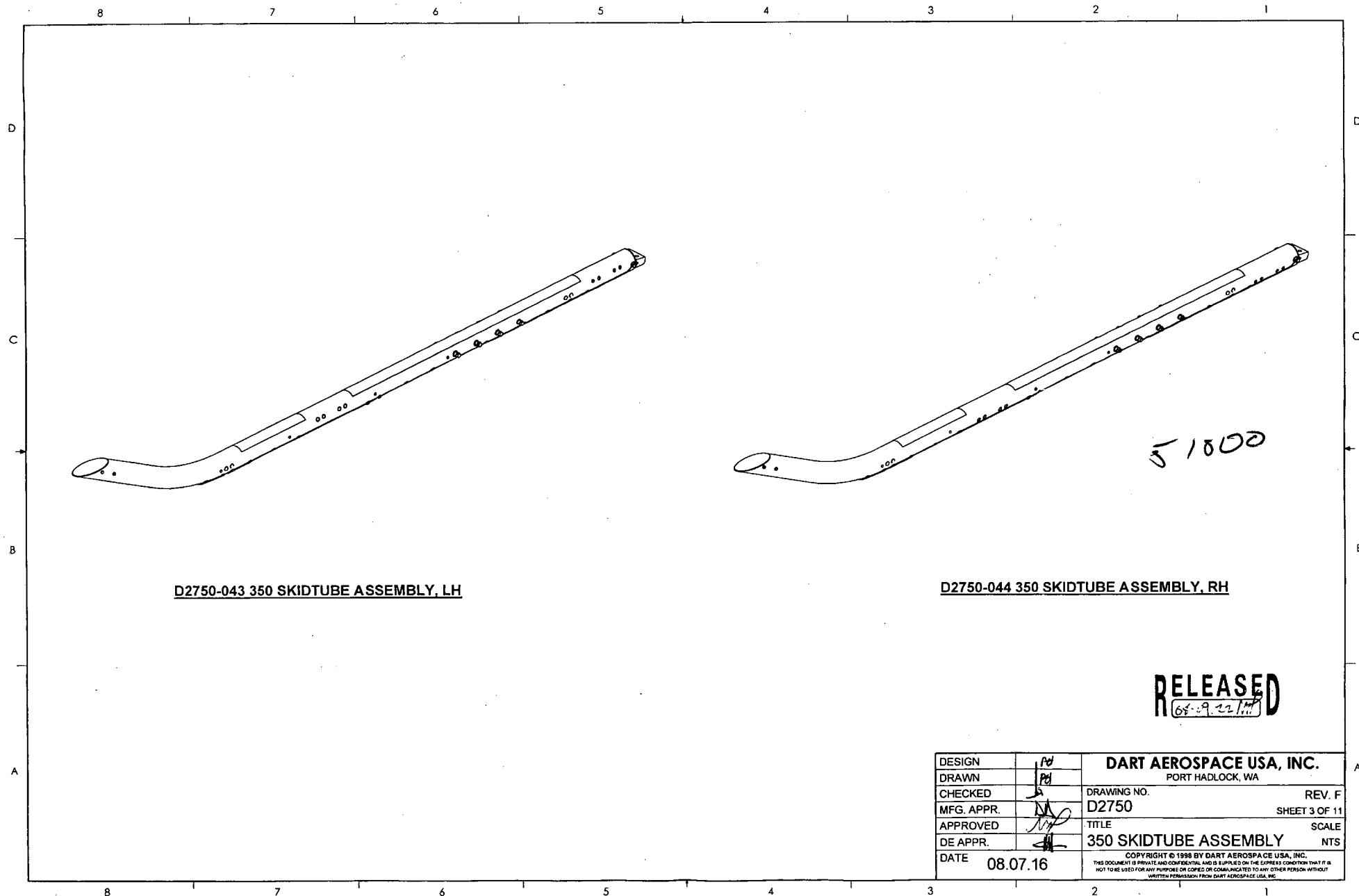


D2750-041 350 SKIDTUBE ASSEMBLY, LH

D2750-042 350 SKIDTUBE ASSEMBLY, RH

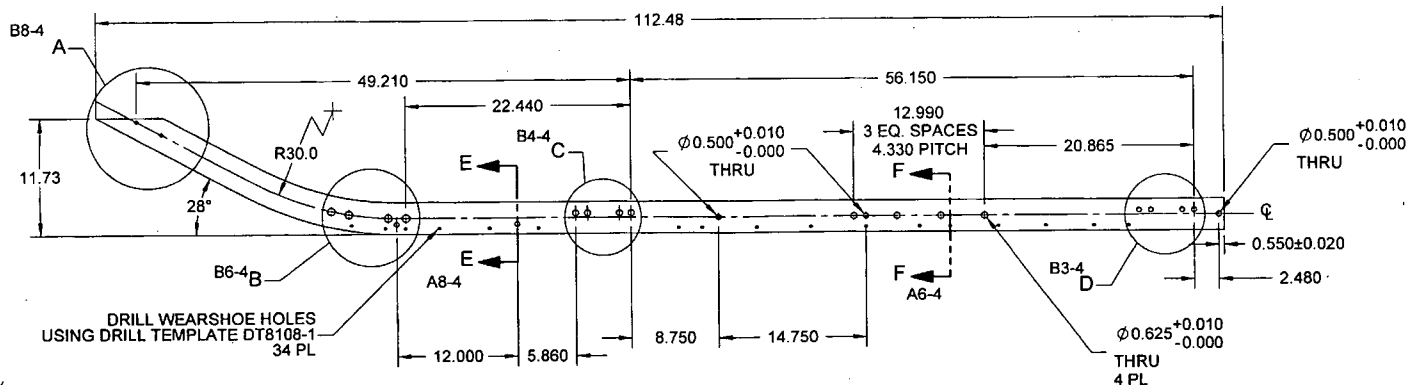
RELEASED
08.07.16

DESIGN	PCW	DART AEROSPACE USA, INC.	
DRAWN	AM	PORT HADLOCK, WA	
CHECKED	AM	DRAWING NO. D2750	REV. F
MFG. APPR.	AM	SHEET 2 OF 11	
APPROVED	AM	TITLE	SCALE
DE APPR.	AM	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

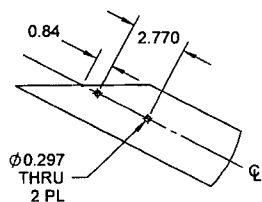


RELEASED
68-9-22/111

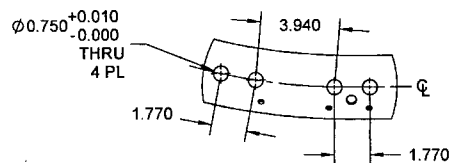
DESIGN	PD	DART AEROSPACE USA, INC.	
DRAWN	PD	PORT HADLOCK, WA	
CHECKED	J	DRAWING NO. D2750	REV. F
MFG. APPR.	NA	SHEET 3 OF 11	
APPROVED	NA	TITLE	SCALE
DE APPR.	NA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



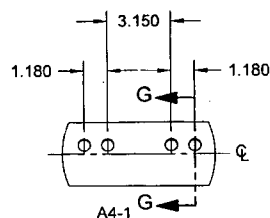
D2750-1 LH SKIDTUBE



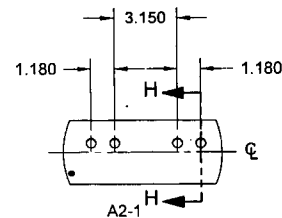
DETAIL A
SCALE 2X



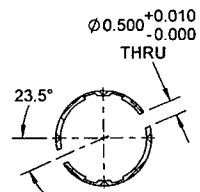
DETAIL B
SCALE 2X



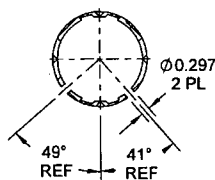
DETAIL C
SCALE 2X



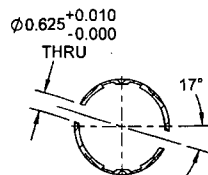
DETAIL D
SCALE 2X



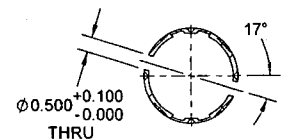
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



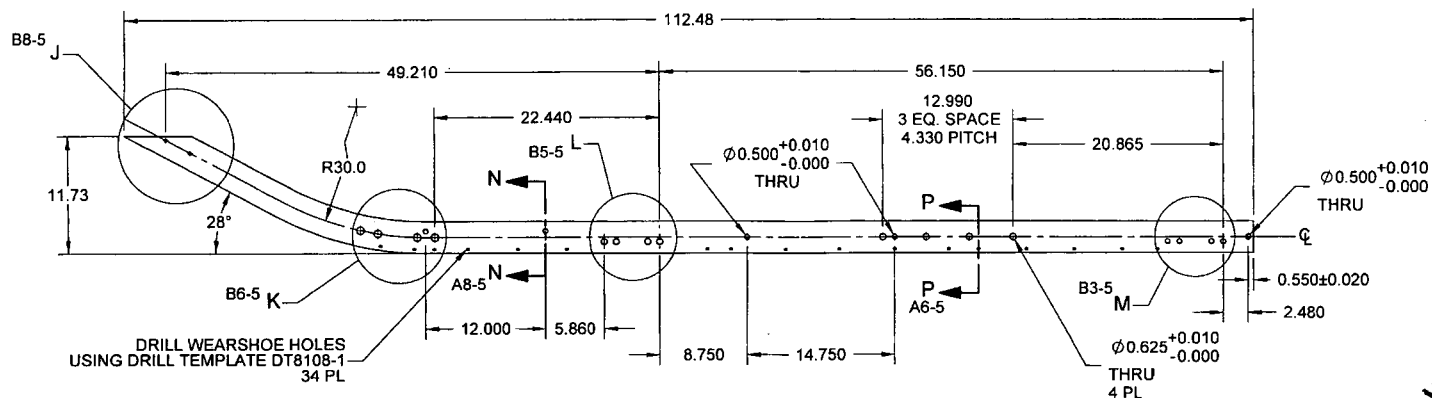
SECTION G-G
SCALE 3X, 4 PL



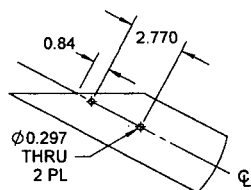
SECTION H-H
SCALE 3X, 4 PL

RELEASED

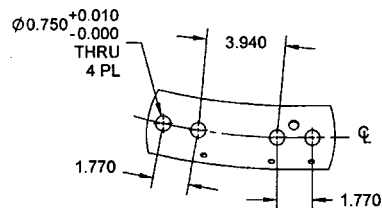
DESIGN	PM	DART AEROSPACE USA, INC.	
DRAWN	PM	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1988 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



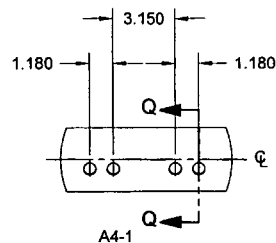
D2750-2 RH SKIDTUBE



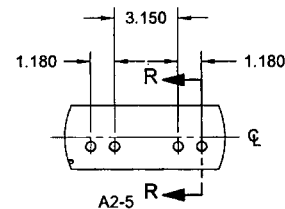
DETAIL J
SCALE 2X



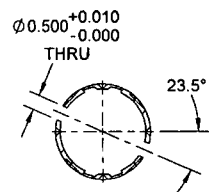
DETAIL K
SCALE 2X



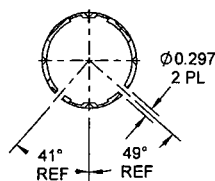
DETAIL L
SCALE 2X



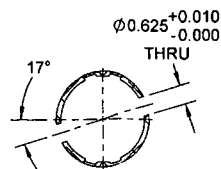
DETAIL M
SCALE 2X



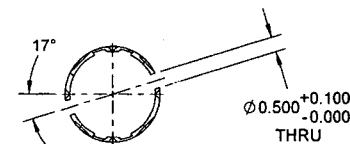
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

RELEASED

DESIGN	REV	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

8

7

6

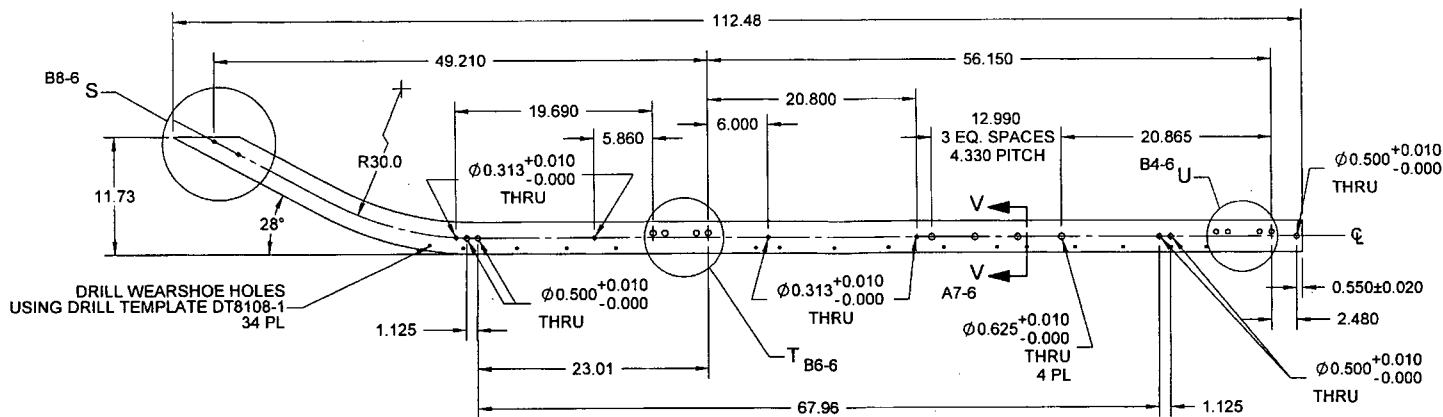
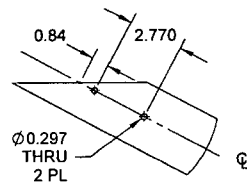
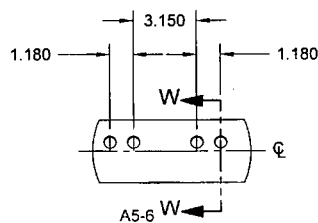
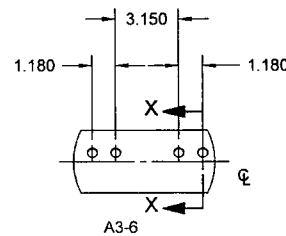
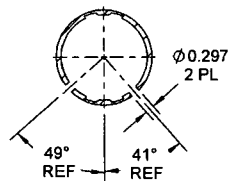
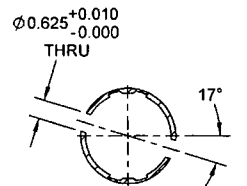
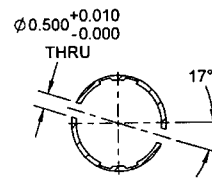
5

4

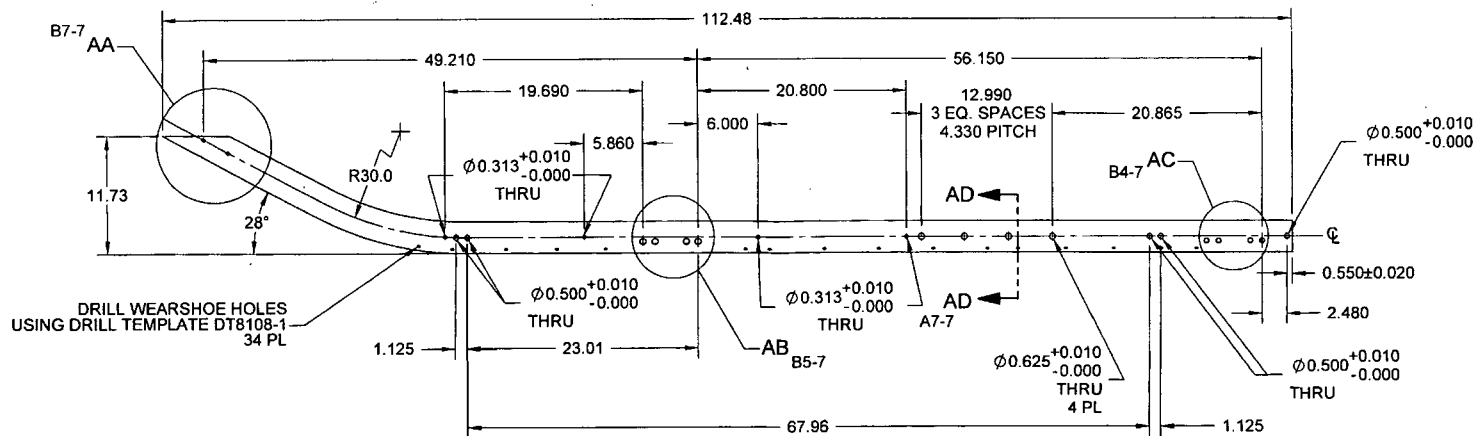
3

2

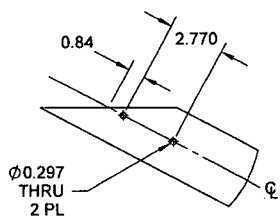
1

**D2750-3 LH SKIDTUBE****DETAIL S**
SCALE 2X**DETAIL T**
SCALE 2X**DETAIL U**
SCALE 2X**SECTION V-V**
SCALE 3X, 17 PL**SECTION W-W**
SCALE 3X, 4 PL**SECTION X-X**
SCALE 3X, 4 PL**RELEASED**
08.07.16

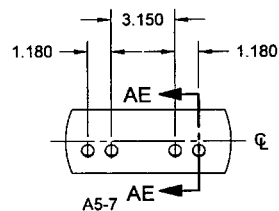
DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 6 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
DE APPR.		COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
DATE	08.07.16	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



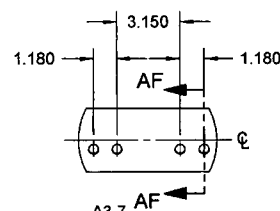
D2750-4 RH SKIDTUBE



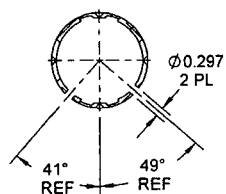
DETAIL AA
SCALE 2X



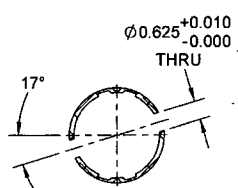
DETAIL AB
SCALE 2X



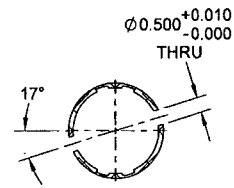
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



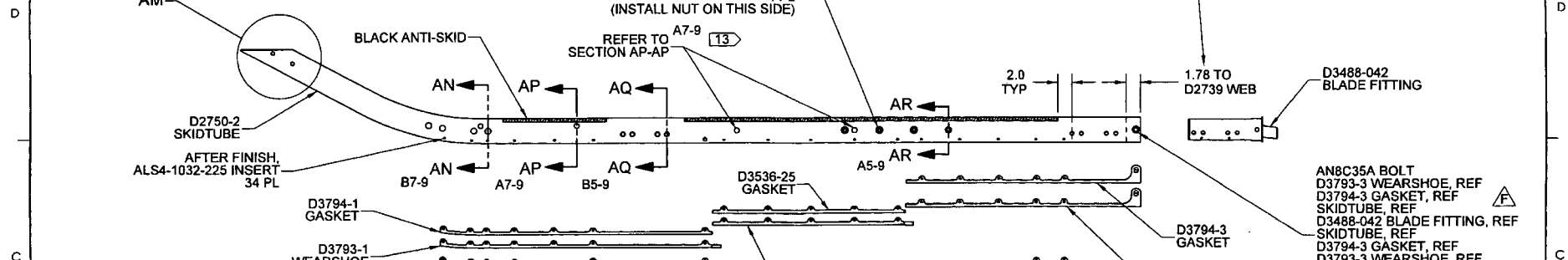
SECTION AF-AF
SCALE 3X, 4 PL

51800

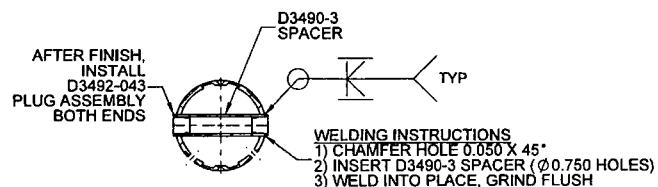
RELEASED
08-04-2010

DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 7 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

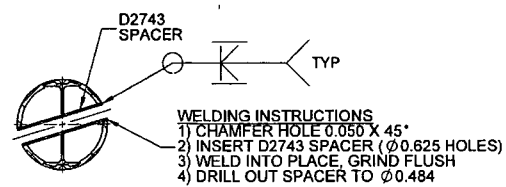
8 7 6 5 4 3



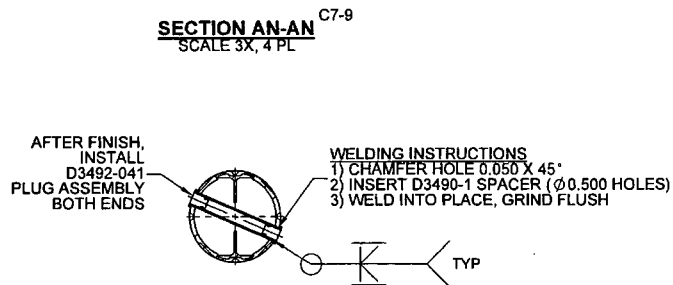
D2750-042 350 SKIDTUBE ASSEMBLY, RH



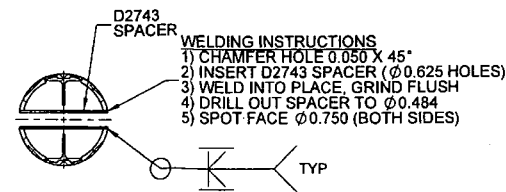
SECTION AN-AN
SCALE 3X, 4 PL



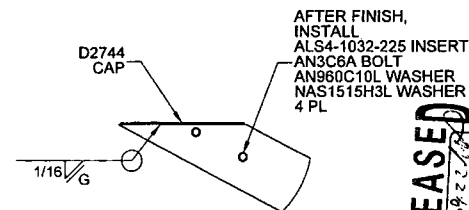
SECTION AQ-AQ
SCALE 3X, 4 PL



SECTION AP-AP C6-9, D5-9
SCALE 3X, 4 PL



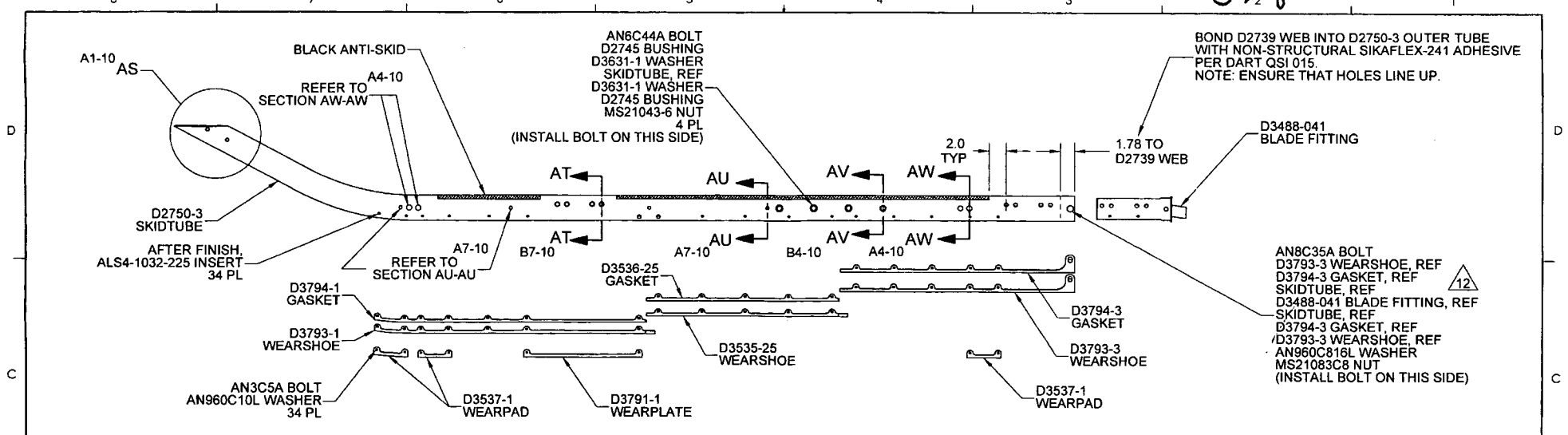
SECTION AR-AR
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



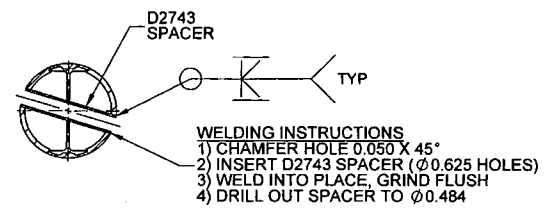
DETAIL AM
SCALE 2X

DESIGN	<i>PH</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>PH</i>	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	<i>MD</i>	D2750	SHEET 9 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS NOT TO BE REPRODUCED IN ANY MANNER OR BY ANY MEANS OR FOR ANY PURPOSE OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE USA, INC.</small>	

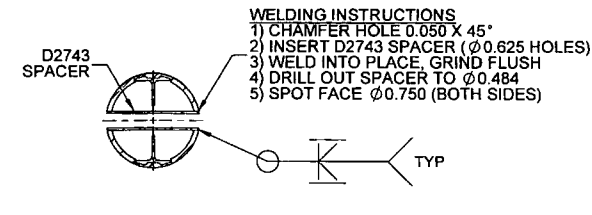
52800



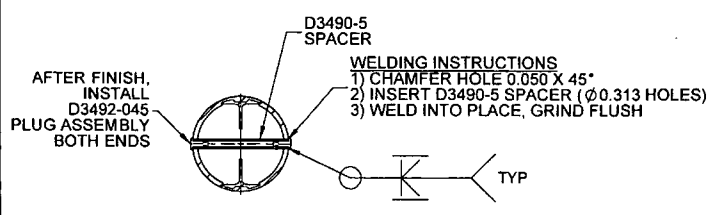
D2750-043 350 SKIDTUBE ASSEMBLY, LH



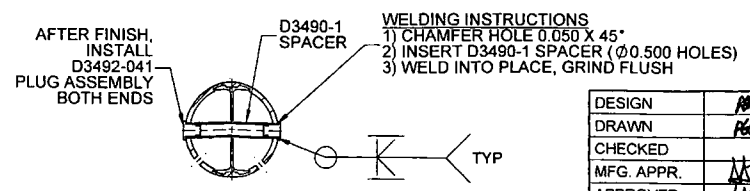
SECTION AT-AT
SCALE 3X, 4 PL



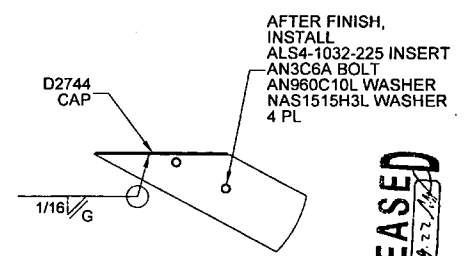
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION AU-AU
SCALE 3X, 4 PL



SECTION AW-AW
SCALE 3X, 4 PL

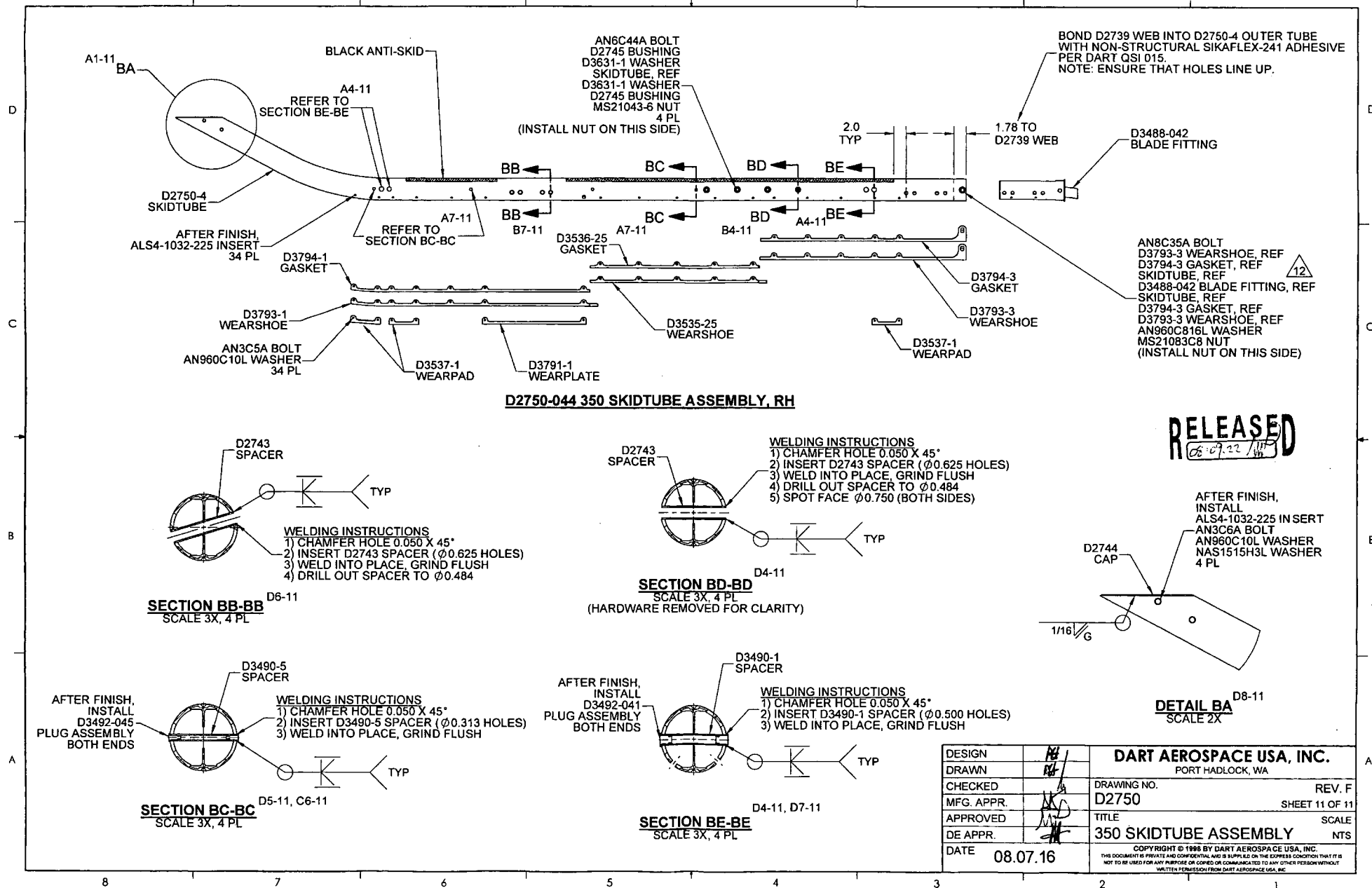


DETAIL AS
SCALE 2X

DESIGN	REV. 1	DART AEROSPACE USA, INC.	
DRAWN	REV. 1	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

RELEASED
2018-08-22/100

51800



NO. 209

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: A. R. Avel
Job number: 51803
Part number: A350-636-011
Description: 350 Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Avel Date of Test Coupon 09/09/28
Welder Pat Paul Date of Test Coupon 09.09.28

The above named individual is qualified in accordance with AWS D17.1.2001 to weld